

Date: Thursday, 3/23/2006 3:44:37 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	WEARPLATE
Job Number	26350		Part Number	D25771
Estimate Number	10288		Drawing Number	D2577 REV E
P.O. Number	N/A		Project Number	N/A
This Issue	3/23/2006	S.O. No. N/A	Drawing Revision	E
Prsht Rev.	NC		Material	N/A
First Issue	N/A	Type PURCHASED PARTS	Due Date	4/15/2006
Previous Run	25137		Qty:	50
Written By	See Comment Below.			
Checked & Approved By	Off 06.03.24			
Comment	Est: E	02.09.24 Re-format; Incorporated D2577-101-11KJ/ RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
	Comment: PURCHASING Issue P/O: <u>00000892</u> <i>6/6/03/28</i>	
	Email or Ship DXF file to vendor Laser Cut per Dwg D2577 flat pattern D2577-101	<i>(30)</i>
	Material release note required	
2.0	D25771F	Wearplate Fwd
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s) WEAR PLATE FWD	
3.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material release note is attached	<i>1/4/4/18 52</i>
4.0	QC6	DIMENSIONAL CHECK
	Comment: DIMENSIONAL CHECK Inspect dimensions per template D2577-101T	<i>1/4/4/18 52</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr	<i>N/A 80 06/01/02 50</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/23/2006 3:44:37 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 26350

Part Number: D25771

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on brake as per Dwg D2577 using DT8155 and DT8179

FF 06.04.20

50

2-Form joggle as per Dwg D2577 using DT8157

FF 06.04.20

50

3-Identify as D2577-1

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8308A & DT8308B as per Dwg D2577

50

Qty Description Batch

A/R 7560 Hardcoat Rod

M100452

H.M 06-04-27

50

9.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11/06/05/02 (50)

10.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

DL 06/05/03 (50)

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 05 03 (50)

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP 19

DC 06/05/03 (50)

13.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

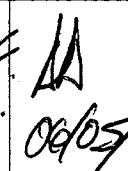
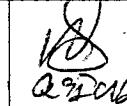
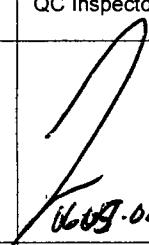
Inspection Level 21

10/06/05/04 (50)

11/06/05/04 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/05/02
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.05.02	8	13 10 w/emplates need to be re-welded. Hardcast didn't penetrate enough into the w/emplate. Lack of heat on the torch.	 06/05/02	PASS the torch over the strikers, and re-apply hard cast as necessary. As per QSI WO	M.F. 06.05. 02.	 06/05/02	 06/05/02	 06/05/02

NOTE: Date & initial all entries

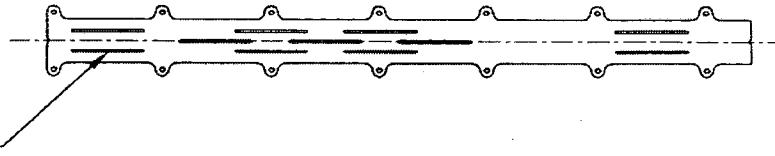
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308

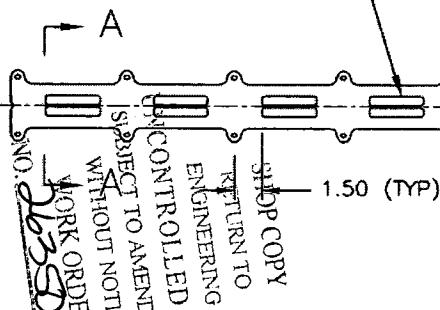


D2577-1 & D2577-3 WEARSHOE

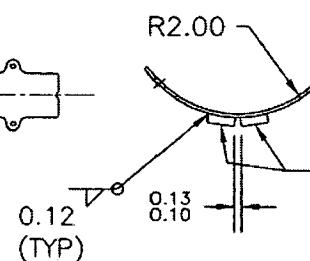
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2941-300
SHWAYDER WEAPADS
(8 PLACES)



SECTION A-A
SCALE 1:5



D2577-1 & D2577-23 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

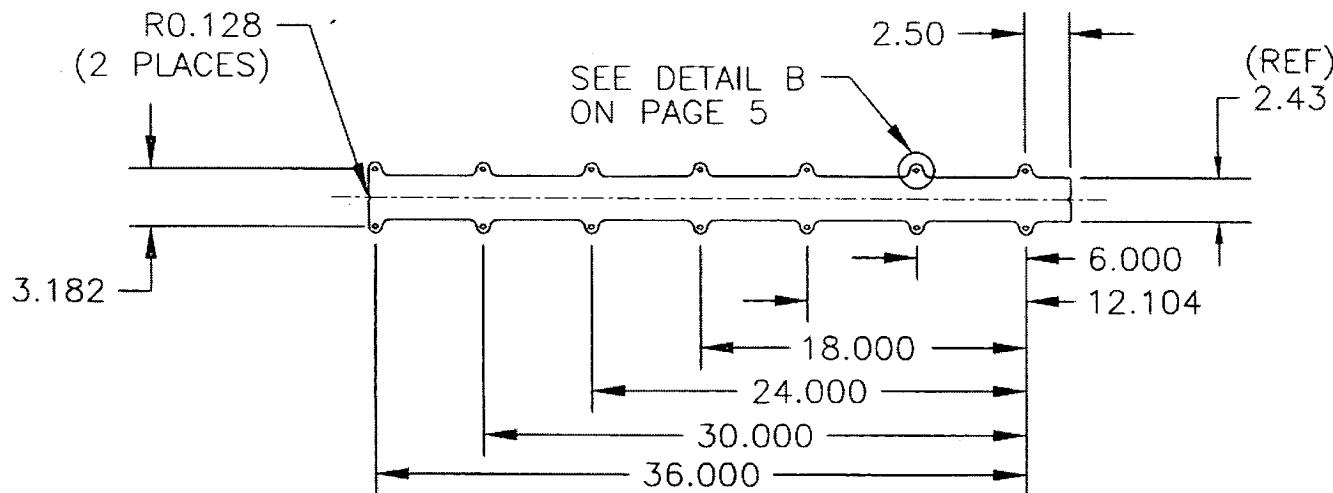
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GACO
QSI 018

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DATE		TITLE	SCALE
A	96.09.16	NEW ISSUE	1:10
B	96.12.04	ADD HARDCOAT WELDS	
C	97.05.30	CHANGE HOLES TO O-BOUNDS	
D	98.08.17	CORRECTED DIMENSIONS ON -1 & -3	
E	00.09.22	ADD D2577-101/-11/-13 INCORPORATE DE09176	

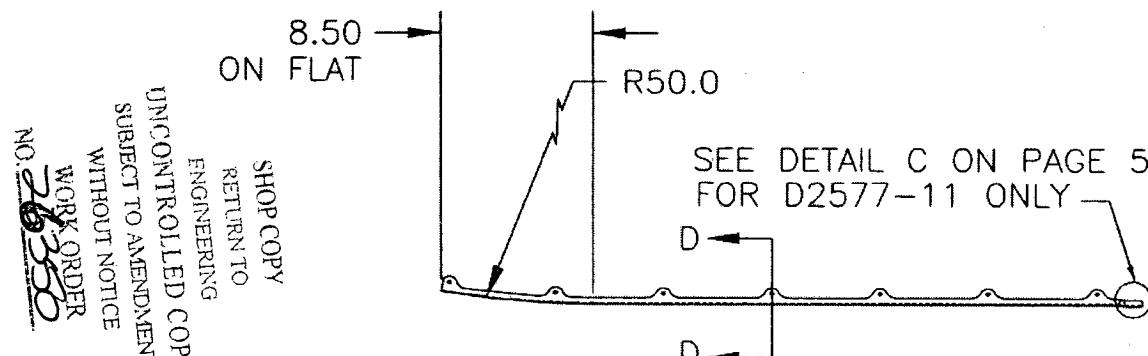


D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-11 & D2577-13 LONGITUDINAL BEND

MAKE FROM D2577-101

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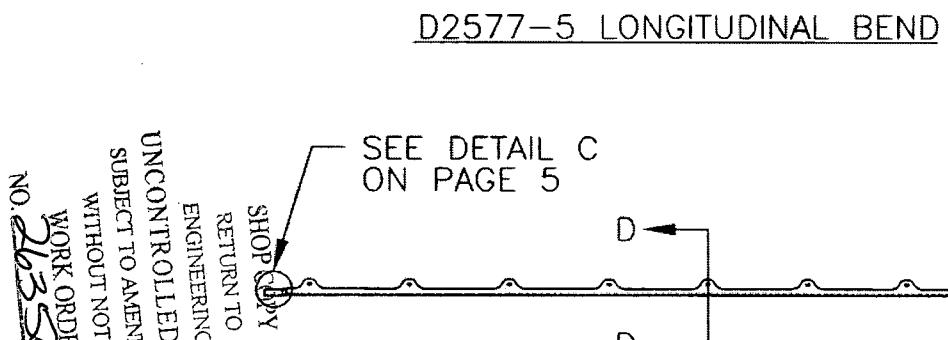
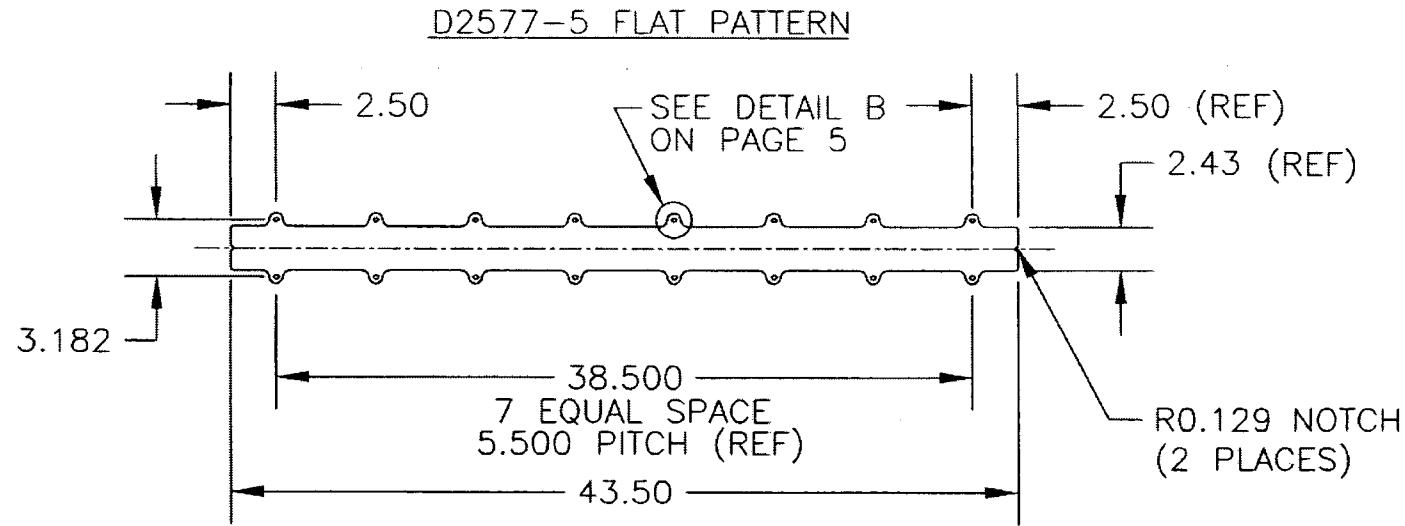
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DATE		TITLE	SHEET 2 OF 5
00.09.22		WEARSHOE	SCALE
			1:10

DART

08-01-26
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0315



D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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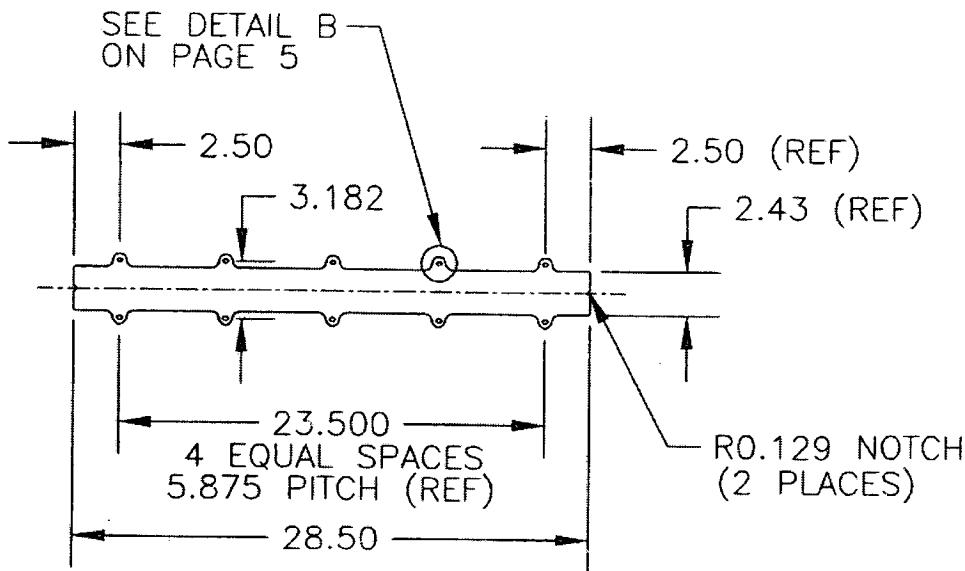
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DATE	TITLE	WEARSHOE	SCALE 1:10

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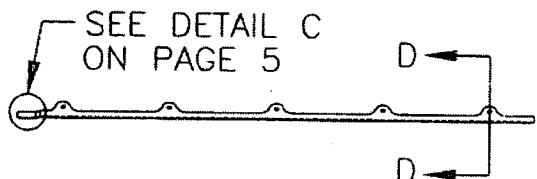


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		SCALE
		1:10

D2577-7 FLAT PATTERN



D2577-7 LONGITUDINAL BEND



D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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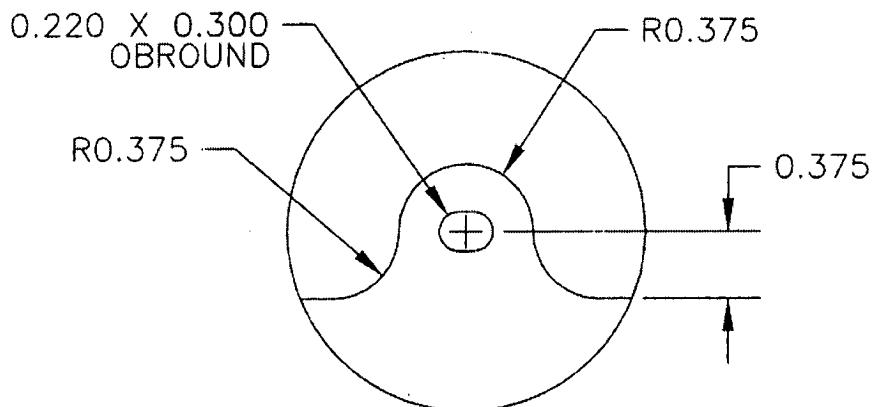


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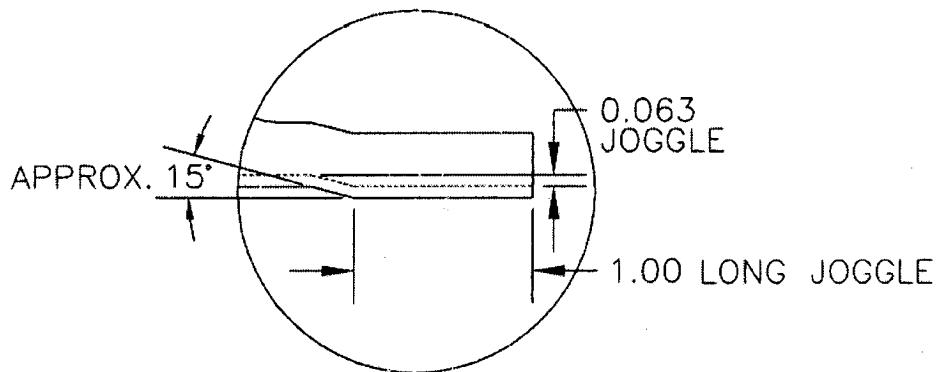
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DATE		REV. E SHEET 5 OF 5 SCALE 1:10
00.09.22		TITLE WEARSHOE

DETAIL B (SCALE 1:1)

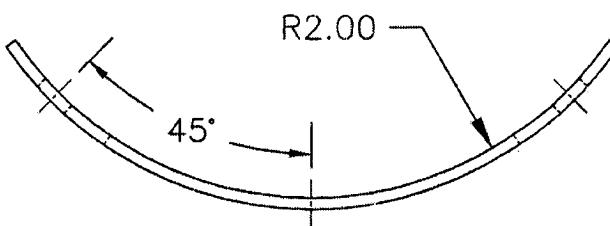
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DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



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New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 22121, Auckland, New Zealand
Telephone: (64-9) 839 371 8111 (Auckland)
(64-204) 820 0720 (Wellington)
(64-9) 839 8888

TEST CERTIFICATE

Ref: 537022917

CUSTOMER	WILLIAMS	REF: 5050501002	SPECIFICATION	ASTM A193W C3 Type A	CERTIFICATE NO.	TC115636
CUSTOMER ORN	50-12N-712		PRODUCT	CR4 WIDE COIL	PAGE	1 of 1
SELL ORN	405546		DIMENSIONS	0.63" x 48" x Coil	DATE	05 August 2008

PACK NUMBER	HEAT NO	CHEMICAL COMPOSITION PERCENT												MECHANICAL TESTS (TEST SPECIFICATION - ASTMA383)									
		C	Si	Mn	P	S	Cr	Ni	Cu	Nb	V	Mo	T	E. NO	CEI	SEND	YIELD	T.S.	WELONG	HARDNESS		LENGTH	
		x100	x100	x100	x100	x100	x100	x100	x100	x100	x100	x100	x100	x1000	x100	100*							(mm)
R9-46011-00	779653	0.6	0.18	0.20	0.02	0.01	17	15	13	14	2.1	0.9	0.2	3	3	Good				45		2015	
R9-46011-00	779653	0.6	0.18	0.20	0.02	0.01	17	15	13	14	2.1	0.9	0.2	3	3	Good				45		2014	
R9-46011-00	779675	0.4	0.18	0.18	0.02	0.01	16	13	11	13	1.1	0.3	0.4	3	3	Good				45		2013	
R9-46011-00	779675	0.6	0.18	0.20	0.02	0.01	16	13	11	13	2.1	0.9	0.2	3	3	Good				50		2012	
R9-46011-00	779674	0.6	0.18	0.20	0.02	0.01	17	13	12	13	2.1	0.9	0.2	3	3	Good				50		2013	
R9-46011-00	779674	0.6	0.18	0.20	0.02	0.01	17	13	12	13	2.1	0.9	0.2	3	3	Good				55		2014	

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (GL) (A)=200mm (B)=50mm	PLASTIC STRAIN RATIO (G) (A)=0 (B)=50	IMPACT TEST (C)=1mm x 5mm (D)=2.5mm x 10mm (E)=2.5mm x 10mm	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn (B)=C+Mn+0.25(Ni+Cr+Mo+V)/15 (C)=C+Mn+0.25
--	--	---	--	---

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Anton Misra*
DOWMETALLURGUE